

Work Order ID 52984

October 20, 2009 11:54:14 AM



Page 1

Item ID:	D3443-3	Accept		Setup	Start	
Revision ID:	C				Stop	
Item Name:	Clevis					
Start Date:	21/10/2009	Start Qty:	10.00	Cust Item ID:		
Required Date:	28/10/2009	Req'd Qty:	10.00	Customer:		

Reference:

Approvals:	Process Plan:	<i>BS</i>	Date:	<i>09-10-20</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3443	Rev C								

100



Doosan

Doosan Lathe

Memo

1-TURN AS PER FOLIO FA588 & DWG D3443
FOLIO REV: *AA*
DWG REV: *C*
2-DEBURR AS REQUIRED

0.00

0.00

09.10.29

150



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

09.10.29 (10)

160



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

09/10/29 (10)

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Page 2

Item ID: D3443-3

Accept



Setup Start



Revision ID: C

Stop



Item Name: Clevis

Start Date: 21/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 28/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location: Carl

0.00



Packaging

Memo

0.00

Packaging

9/10/29 @ SP

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/29

MF 09-10-29

Picklist Print

October 20, 2009 11:54:18 AM

Page 1

Work Order ID: 52984



Parent Item: D3443-3RevC



Parent Item Name: Clevis

Start Date: 21/10/2009

Required Date: 28/10/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304R1.500		Purchased	No			100	f	20.9000	2.5000			

304 round bar 1.500

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

20.9

106260

20.9

2.75'

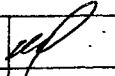
up 09.10.29

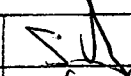
DART AÉROSPACE LTD		Work Order: 52984
Description: Clevis		Part Number: 1D34H3-3
Inspection Dwg:	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.438	+0.005 - 0.0	.439	/			
2.70	+/- .030	2.707	/			
45°	+/- 1/2°	45°	/			
R.219	+/- .010	R.220	/			
.500	+0.0 - 0.005	.498	/			
1.00	+/- .030	1.000	/			
1.125	+/- .010	1.127	/			
R.450	+/- .010	R.450	/			
.375 Ø	+0.006 - .001	.375	/			
20° TP	+/- 1/2°	20°	/			
.820	+/- .010	.817	/			
.551	+/- .010	.555	/			
1.43	+/- .030	1.431	/			
.625	+/- .010	.621	/			
.95	+/- .030	.940	/			
.05 x 45°	+/- .030	.05	/			
.1285 Ø	+0.005 - 0.0	.129	/			

Measured by: 
Date: 09.10.29

Audited by: 
Date: 09/10/29

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3443-041	STRUT WELDMENT ASSEMBLY
2	1	D3443-1	LUG
3	1	D3443-5	TUBING
4	1	D3453-1	CLEVIS
5	1	D3965-4	BEARING, SPHERICAL
6	2	D3966-4-750	PIN, DOWEL

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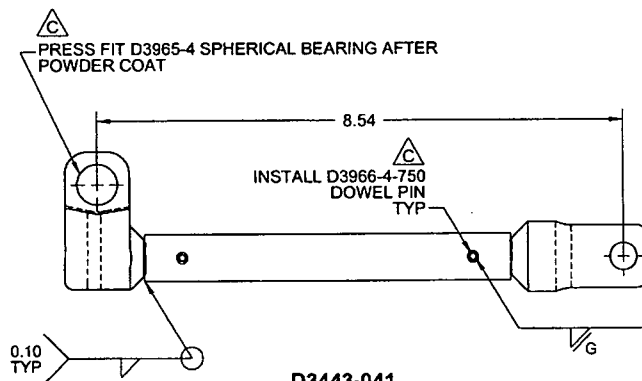
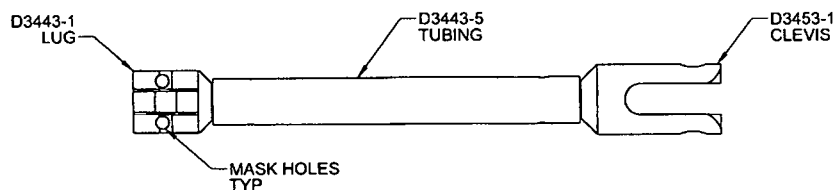
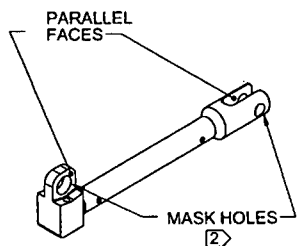
13/09-10-20

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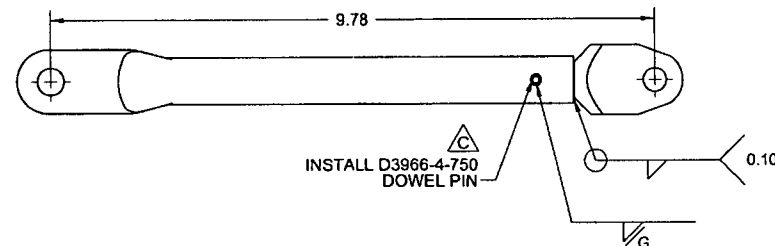
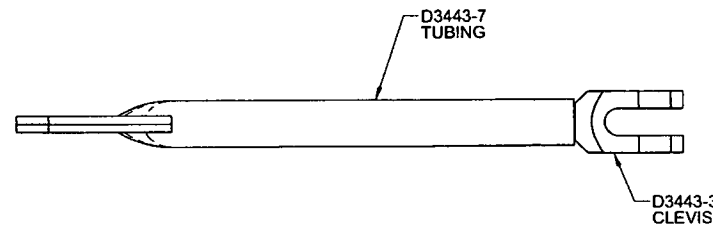
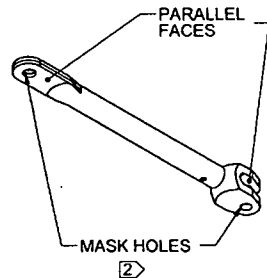
C	DRAWING UPDATED TO CURRENT STANDARDS. REVISED NOTE #2 (ZN A8-1, A8-2); 0.820 WAS 0.720 & 1.43 WAS 1.53 (ZN C2-3); 0.551 WAS 0.451 (ZN C1-3); R0.219 WAS R0.050 (ZN C4-3); D3965-4 WAS SPAENAUER P/N (ZN C6-1, B5-2); D3966-4-750 WAS McMASTER-CARR P/N (ZN B5-1); REF PAR 09-018	RF	09.06.25
B	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø0.125 WAS #30	RF	05.12.05
A	NEW ISSUE	RF	05.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>UP</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3443	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	STRUT WELDMENT ASSEMBLY NTS	
DATE	09.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.33 lbs
- 8) WELD PER DART QSI 004



ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3443-043	STRUT WELDMENT ASSEMBLY
2	1	D3443-3	CLEVIS
3	1	D3443-7	TUBING
4	1	D3966-4-750	PIN



D3443-043

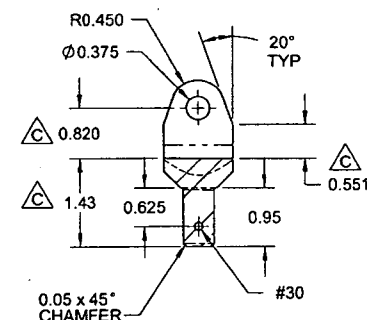
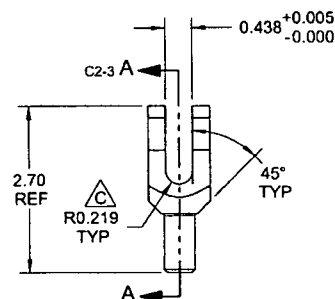
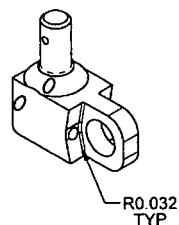
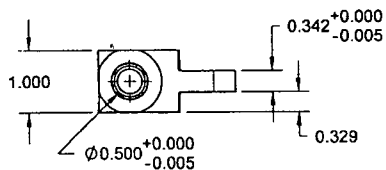
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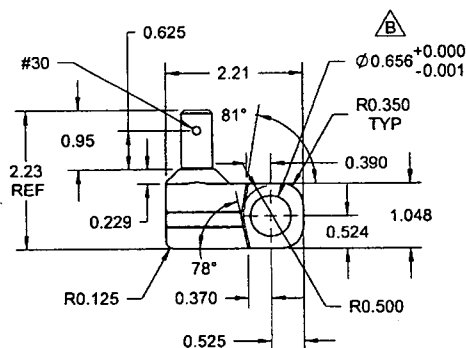
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs
- 8) WELD PER DART QSI 004

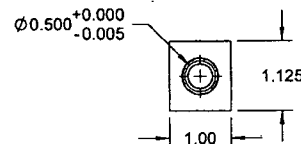
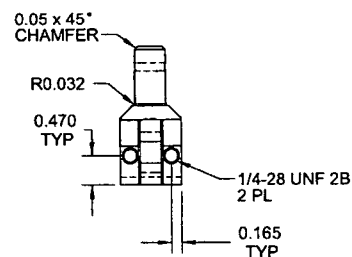
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DRAWN	RF		
CHECKED	UP	DRAWING NO. D3443	REV. C
MFG. APPR.		TITLE	SCALE
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SECTION A-A C4-3



D3443-1 LUG



D3443-3 CLEVIS

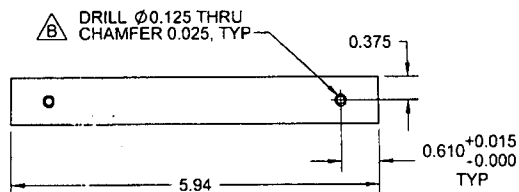
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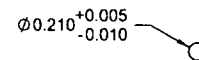
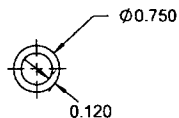
- 1) MATERIAL: D3443-1 = 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)
D3443-3 = AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-1 = 0.50 lbs
D3443-3 = 0.35 lbs

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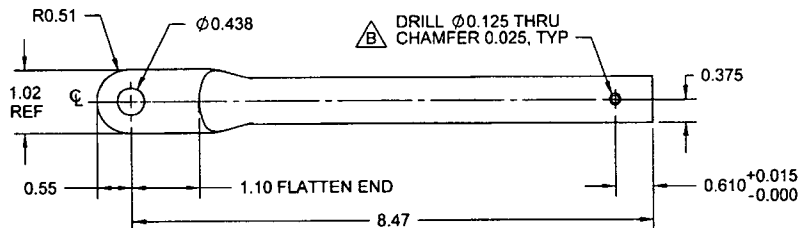
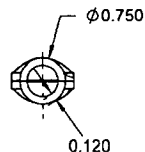
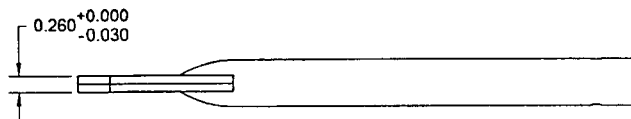
D3443-5 TUBING



D3443-9 PIN

D3443-9 NOTES:

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A







D3443-7 TUBING

D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.025 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-5 = 0.41 lbs
D3443-7 = 0.62 lbs

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